












Date: Friday, 1/13/2006 10:10:44 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BRACKET
<b>Job Number</b>	: 25492	<b>Part Number</b>	: D31261
<b>Estimate Number</b>	: 10737	<b>Drawing Number</b>	: D3126 REV A1
<b>P.O. Number</b>	: N/A	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 1/13/2006	<b>Drawing Revision</b>	: A1
<b>Prsht Rev.</b>	: NC	<b>Material</b>	: N/A
<b>First Issue</b>	: N/A	<b>Due Date</b>	: 1/20/2006
<b>Previous Run</b>	: 24679	<b>Qty:</b>	20
<b>Written By</b>	: SEE COMMENT BELOW	<b>Um:</b>	Each
<b>Checked &amp; Approved By</b>	: SEE ABOVE USER & DATE		
<b>Comment</b>	: Est A03.01.15 New issue KJ/RF		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	PG	PURCHASING	
			
<b>Comment:</b> PURCHASING Issue P/O: 00000385 Email or ship Dxf file to vendor Laser cut per Dwg D3126 flat pattern D3126-1 Material: AISI 304/316 SS sheet 0.032" thick per MIL-S-5059(Ref: Dart Spec. M304S) Annealed Material release note required			
2.0	D31261F	Bracket-Flat	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Bracket			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
<b>Comment:</b> PACKAGING RESOURCE #1 Receive and Inspect for transit damage Ensure the material note is attached.			
4.0	QC6	DIMENSIONAL CHECK	
			
<b>Comment:</b> DIMENSIONAL CHECK			
5.0	BRAKE NC	NC BRAKE	
			
<b>Comment:</b> NC BRAKE Deburr if necessary Form on CNC brake as per D3126 using Jig D3126T1 Identify as D3126-1 Scribe Dart P/N as shown on Dwg D3126			

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RA Date: 06/03/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/13/2006 10:10:44 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25492

Part Number: D31261

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Job 03-02*

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *CA-8*

*DC 06/03/02*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DD*

*06/03/02*

Job Completion



*U 06-03-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Shanxi Taigang Stainless Steel CO.,LTD Member  
of Taiyuan Iron and Steel (Group) Co.,LTD**

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China  
TEL: (0351)3013328 FAX: (0351)3017816  
http://www.tisco.com.cn  
E\_mail: tgbxg@tisco.com.cn


**INSPECTION CERTIFICATE**

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	20050651	
DATE OF ISSUE	/ /	

**CUSTOMER**  
Marubeni-Itochu Steel CA.

**CONTRACT NO.**  
V-1193-05

**DATA OF**  
P50527PC001 2005/06/20

Product	Melting furnace	Inspectors stamp	Mark of the Manufacturer
COIL	E+VOD		Shanxi Taiyuan Stainless Steel Co.,ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
1	4501969	5A4-341-1ZJ	1	14GA × 48 × C	7271
2	Y502875	5A4-419-1ZY	1	14GA × 48 × C	7056
3	4502389	5A5-103-3ZD	1	14GA × 48 × C	7216
4	4501968	5A5-383-3ZB	1	18GA × 48 × C	7296
5	Y503062	5A5-488-3ZB	1	18GA × 48 × C	6798
6	4502827	5A5-375-4ZY	1	18GA × 48 × C	6877
<b>Total:</b>			6		42514

**Chemical Composition**

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4501969	0.050	0.430	1.270	0.018	0.002	18.020	8.010				0.050
Y502875	0.053	0.500	1.160	0.032	0.001	18.600	8.010				0.056
4502389	0.060	0.460	1.300	0.018	0.002	18.100	8.100				0.055
4501968	0.060	0.460	1.350	0.018	0.003	18.120	8.100				0.050
Y503062	0.047	0.510	1.150	0.031	0.001	18.400	8.300				0.060
4502827	0.060	0.470	1.310	0.018	0.002	18.140	8.070				0.050

**Mechanical Properties**

Test No.	Tensile R <sub>m</sub> N/mm <sup>2</sup>	R <sub>p0.2</sub> Yield <sub>0.2%</sub> N/mm <sup>2</sup>	R <sub>p1.0</sub> Yield <sub>1.0%</sub> N/mm <sup>2</sup>	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4501969-T	660	287		60		84		
Y502875-T	605	280		64		79		
4502389-T	665	286		57		83 - 83		
4501968-T	685	311		53			178 - 177	
Y503062-T	645	315		63			148 - 147	
4502827-T	665	307		56			192 - 192	
-T								

Surface and dimensions controlled: O.K.

Work Inspecto

*E. H. 35*

*18ga 304 2B SS*

*.036" 10305*

*2602.06*

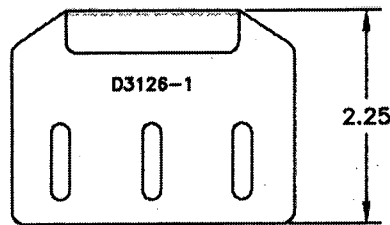
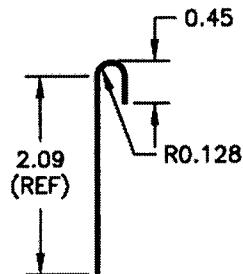
**DART**

SUPERCEDED BY

Rev. B 04.11.24

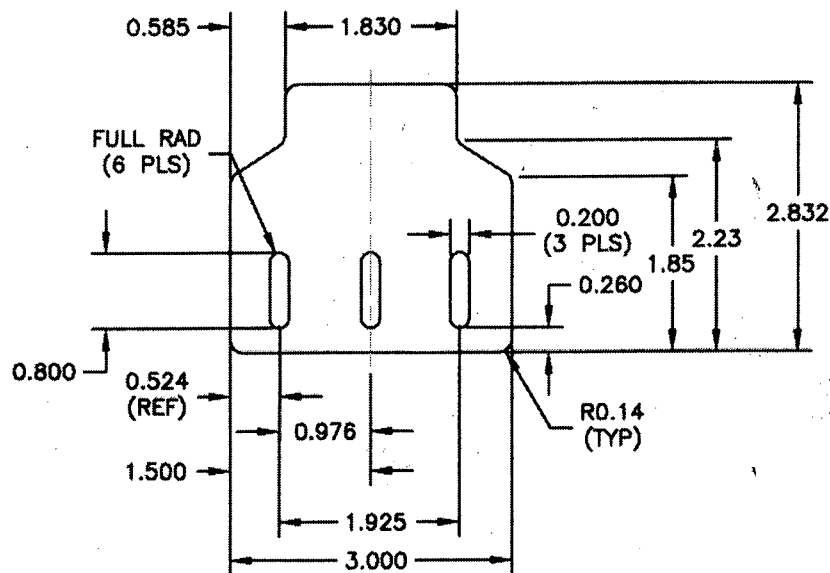


DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3126	REV. A SHEET 1 OF 3
DATE 02.04.17		TITLE BRACKET	SCALE 1:2
A	02.04.17	NEW ISSUE	
AI	02.09.23	ADD "ANNEALED" SPEC	

RELEASED  
02.05.27

D3126-1 BRACKET  
REPLACES PREMIER P/N B30-23000-265

REFERENCE ONLY



D3126-1 BRACKET FLAT PATTERN

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-1 AS SHOWN

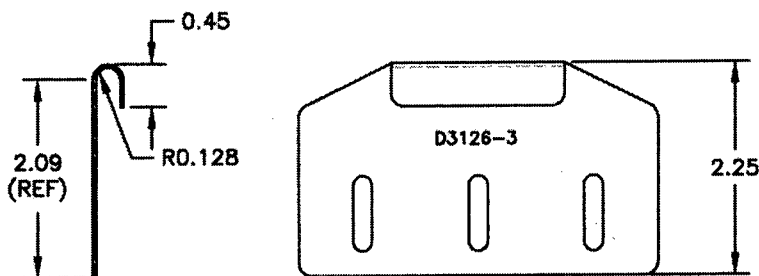
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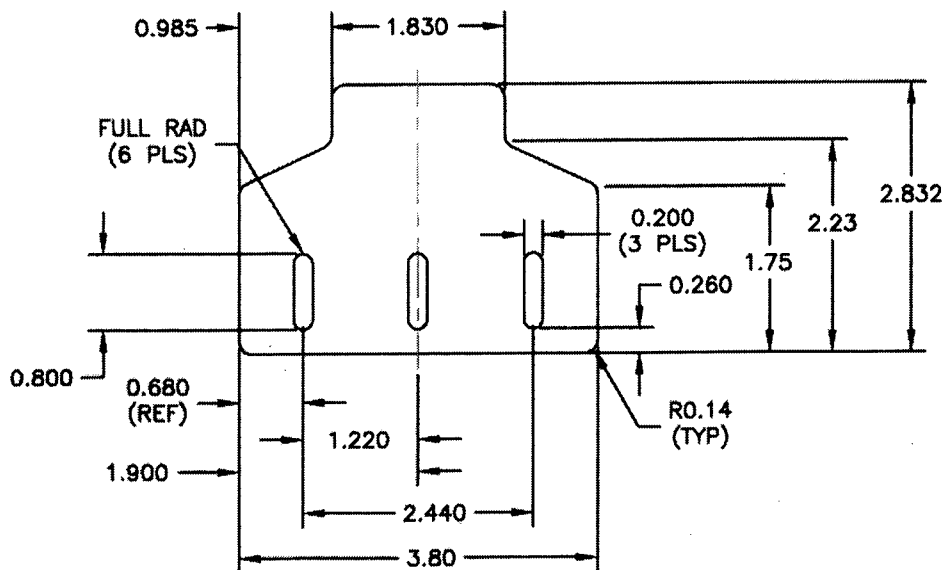
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DATE 02.04.17		TITLE BRACKET	SCALE 1:2

RELEASED  
02.05.27



D3126-3 BRACKET  
REPLACES PREMIER P/N B30-23000-267

REFERENCE ONLY



D3126-3 BRACKET FLAT PATTERN

#### NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-3 AS SHOWN

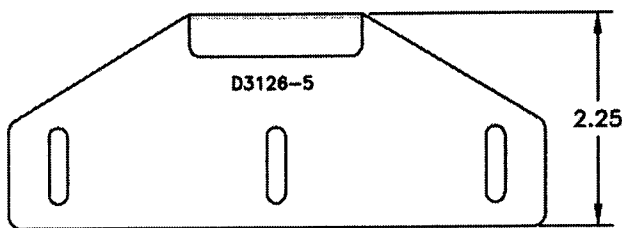
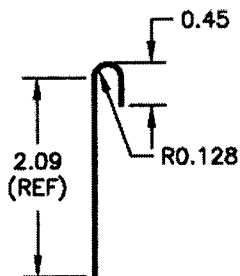
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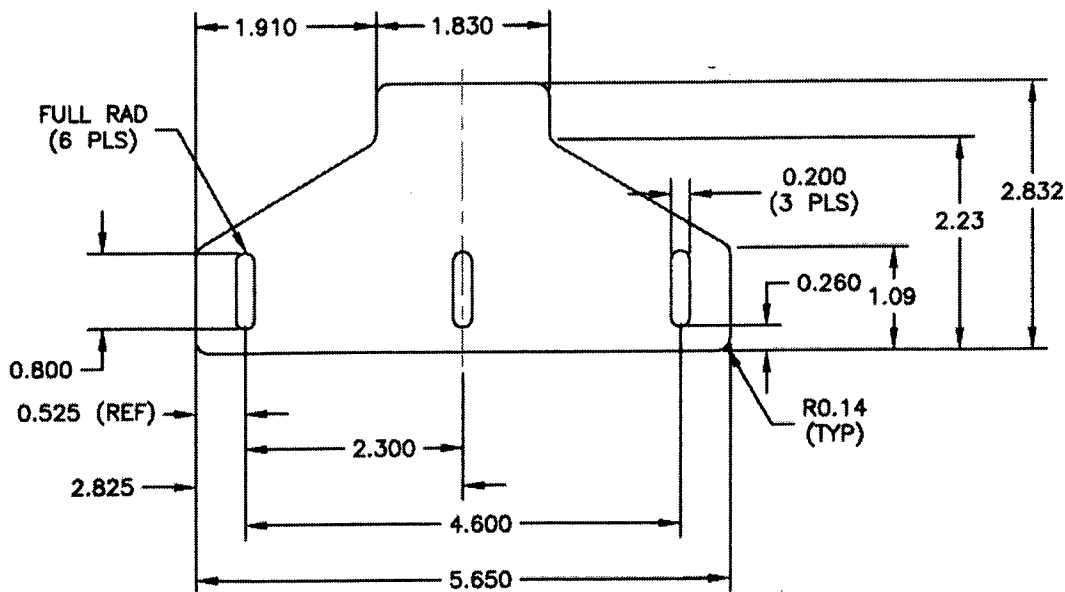
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CHECKED #	APPROVED #	DRAWING NO. D3126	REV. A SHEET 3 OF 3
DATE 02.04.17		TITLE BRACKET	SCALE 1:2

RELEASED  
02.05.27



D3126-5 BRACKET  
REPLACES PREMIER P/N B30-23000-269

REFERENCE ONLY



D3126-5 BRACKET FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-5 AS SHOWN

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